

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017127**Date Inspected:** 07-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

This QA inspector performed MT 15% of back gouged weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path BK004-004. The weld designations reviewed as follows.
BK004A5-004-090.

Green tag issued for the following suspender brackets after NDT carried out successfully.

SB78W-12265.

SB78E (1 stage)- 12295.

SB78E (2 stage)-12277.

FCAW welding of repair buttering of short in length stringer plates BKX8A, BKX10A, BKX9C located on PCMK BK004-002. The welder is identified as 062761. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-3G (3F)-repair and WR14784.

During random in-process visual inspection, Quality Assurance (QA) Inspector observed -ZPMC performing weld repair of one (1) Transverse Indication measuring approximately 10 mm without the prior approval of the Engineer or an approved CWR.

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-Third time weld repair carried out without the prior approval of the Engineer or an approved CWR.

-The weld is Identified as SB019-074-004.

For more information please see the Incident report

04-0120F4_TL-15_B247_09-07-10_SB74E_Third time and Crack Weld Repair without CWR.

BAY#16

FCAW welding of weld joint 2G-020 located on PCMK LD3035-001 of Segment 13BW the welder is identified as 040314. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 2G-065 located on PCMK LD3031-001 of Segment 13AW the welder is identified as 045143. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 1G-002 located on PCMK BP3056-001 of Segment 13AW the welder is identified as 201888. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

BAY#8

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path BK004-056. The weld designations reviewed as follows.

BK004A3-056-025,026.

BK004A4-056-066,067,040.

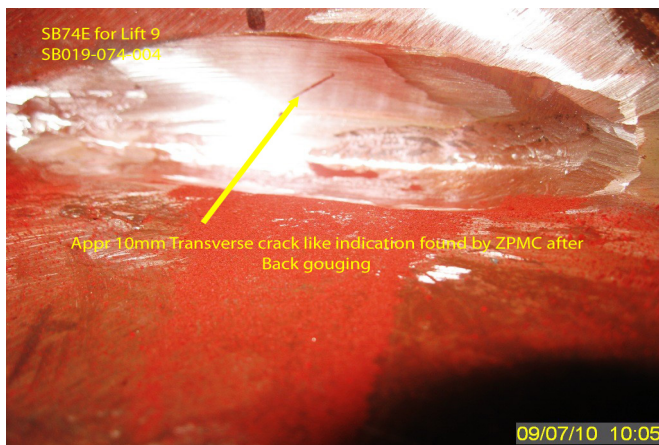
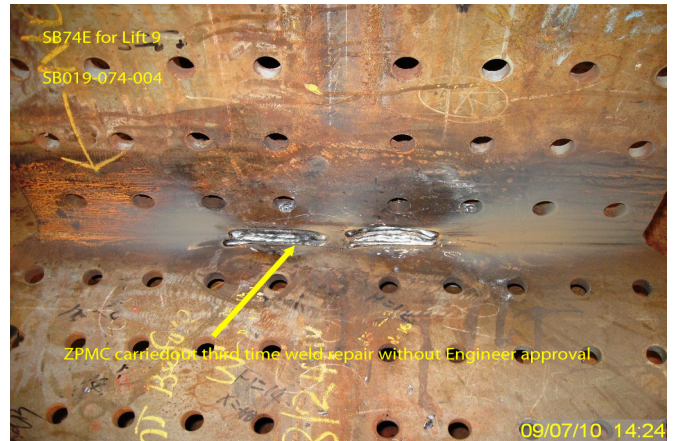
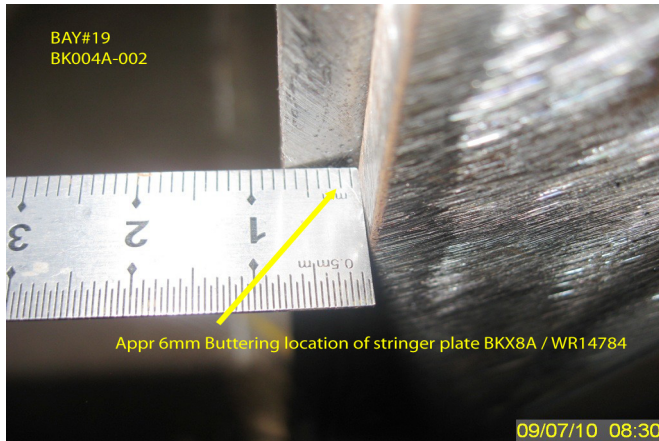
BK004A7-056-037,038,097,098,103,104,178,179,180,169,182,183,198,224,225,231,232,284.

BK004A6-056-014,015,019,025,027,029,030,037,039,042,043,162,045,048,049,059,060,021.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
